

# EUROPEAN PATENT OFFICE

## Patent Abstracts of Japan

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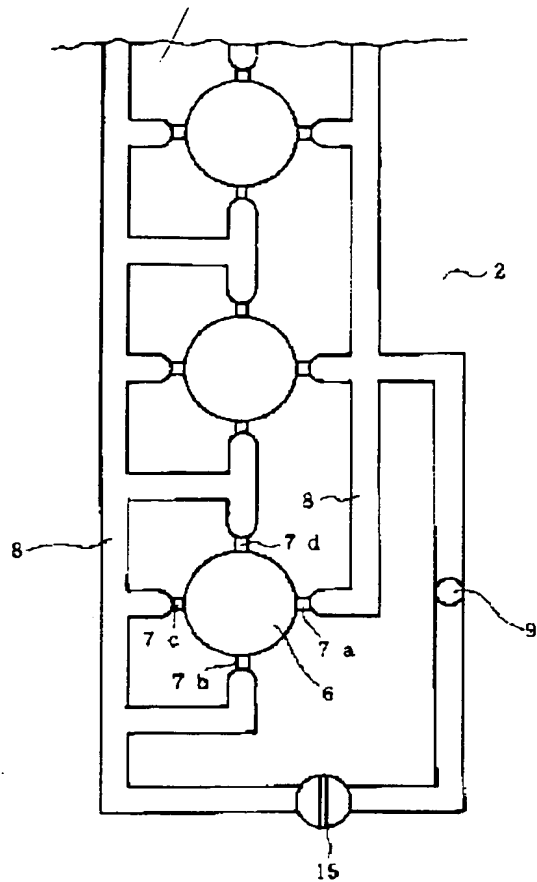
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APPLICANT : HITACHI LTD;

INVENTOR : TANIDE HIDEO;

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TITLE : INJECTION MOLD AND MOLDING  
METHOD



**ABSTRACT :** PURPOSE: To obtain a highly accurate molded product excellent in symmetry of rotation by providing a plurality of gates per one cavity and providing a device controlling the flow of a resin during a period when one of the gates is connected to a sprue.

**CONSTITUTION:** Four gates 7a, 7b, 7c, 7d are provided to each of a plurality of the cavities 6 of a movable mold 2 and a sprue 9 and one gate 7a among four gates are directly connected by a runner 8 and a runner opening and closing device 15 is provided on the way of the runner 8 connecting the remaining three gates 7b, 7c, 7d and the sprue 9. The runner opening and closing device 15 is closed when a resin 12 passes through the sprue 9 and the runner 8. Whereupon, the resin 12 passes through the runner 8 to begin to fill each of the cavities 6 and, after a predetermined time is elapsed, the runner is opened and the once stopped resin 12' begins to again flow toward the gates 7b, 7c, 7d. At this time, since each of the cavities 6 is filled with the resin from the gate 7a, no weld line is generated.

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